

Monday, September 12, 2016 10:31:09 AM

646.3813

150933

Page 1

DAS

21
9-89

Date: SEP 12 2016

Date:

Date:

NR1

Stop

NR2

**Insp.
Stamp**

646.3800

N/C

0.00

~~DAS~~

32

9-89

110

Mill Conv

HAAS CNC VERTICAL MACHINING #1

0.38

Conventional Milling Machine

Memo

1-Machine per DWG
DWG REV: n/c

2- deburr and break all sharp edges

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.01

Quality Control

DAS

32

9-89

16-02-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER :																					

Monday, September 12, 2016 10:31:09 AM

150933

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 8/19/2016 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 9/12/2016 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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QC8- Inspect parts - second check

0.00

130

0.02

QC

Memo

Quality Control

DAS
14
9-28

16/09/23

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

149.99

Outsource4

Memo

Outsource process - Anodize

Issue P/O to ATG : 33802

1- Black Anodize as per Dwg 646.3800

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Comformity is required

SEP 29 2016

DA
13
9.50

Receive & Inspect for Damage & Mat'l Certs

0.00

150

0.02

Packaging

Memo

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order ID 150933***150933***

Page 3

Monday, September 12, 2016 10:31:09 AM

Item ID: 646.3813 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Bracket
Start Date: 8/19/2016 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 9/12/2016 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.02							DAS 38 9-89
Quality Control									OCT 18 2016
180	Identify as per dwg & Stock Location: <u>CCK100</u>	0.00							
180									
Packaging	Memo	0.01							5 OCT 20 2016 DAS 6 9-89
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.08							16/10/2016
Quality Control									

16.10.20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																					

Picklist Print

Monday, September 12, 2016 10:31:12 AM

Page 1

Work Order ID: 150933

150933

Parent Item: 646.3813

646 3813

Parent Item Name: Strut Bracket

Start Date: 8/19/2016

Required Date: 9/12/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6A0.75X0.75X 0.060X0.062		Purchased	No				f	67.8403		0.578947			
*M7075T6A0 75X0 75X0 060X0									**			16-09-21	DAS 32 9-89
7075T6 ANGLE .75" X .75" X .060" X .062"W													

Location

Loc Qty

Loc Code

MAT051

67.840342

123947

67.840342

1.302342

DQA: _____ Date: _____



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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03697				SHEET 1 OF 1	
	DWG NO. 646.3800	REV: N/C	PREPARED BY B. PETERS	DATE: 11/14/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: BRACKETS					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED ALTERNATE MATERIAL.				ECR: D-12-006	

IS

1 PRIMARY MATERIAL: 7075-T651 ALUMINUM PER AMS-QQ-A-250/12.
ALTERNATE MATERIAL: 7075-T6511 ALUMINUM PER AMS-QQ-A-200/11.

SHEET 1, ZONE A2 IS:

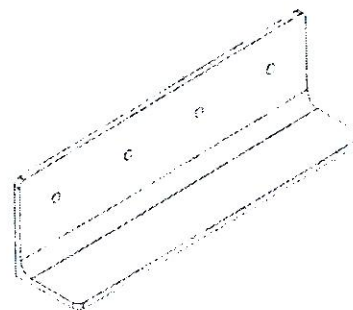
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 150933 MLS
1609-12

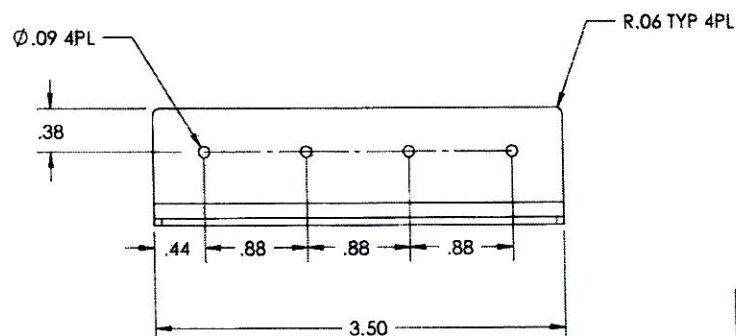
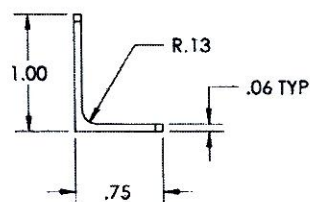
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED: ☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM					CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO

NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377 J TYPE I CLASS N
- 3 DEBURR AND BREAK ALL SHARP EDGES
- 4 IDENTIFY IAW MPP-120



646.3810



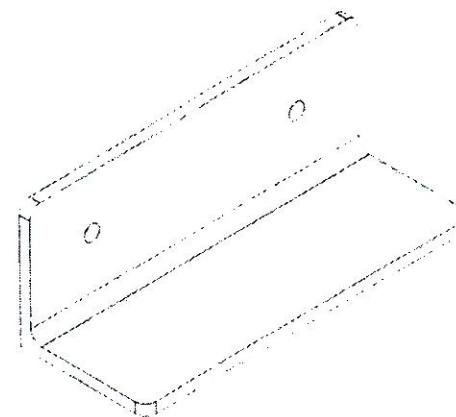
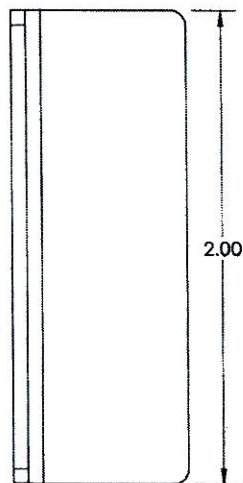
UNINCORPORATED ELL (3)

03697

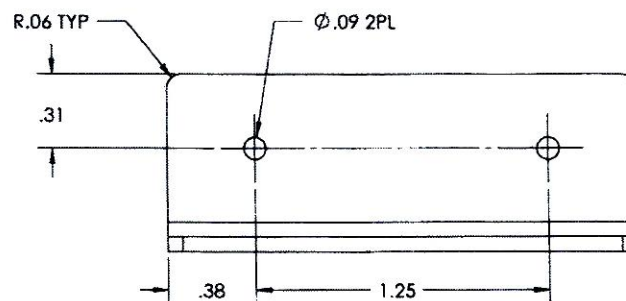
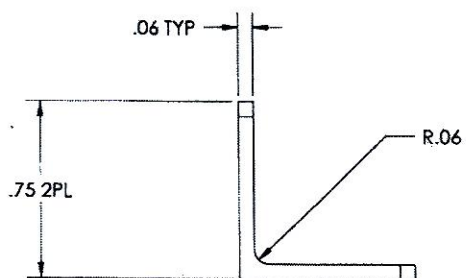
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THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



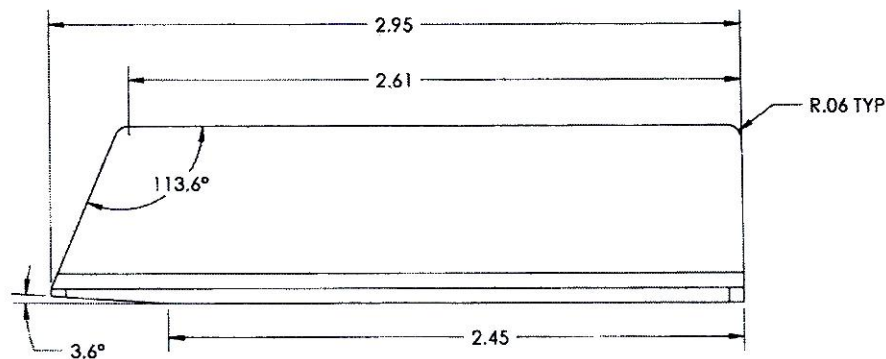
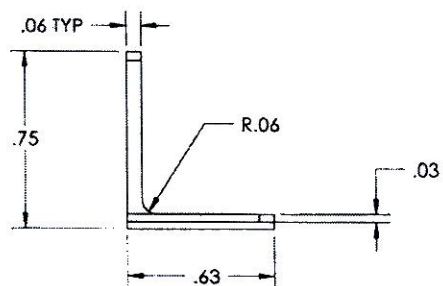
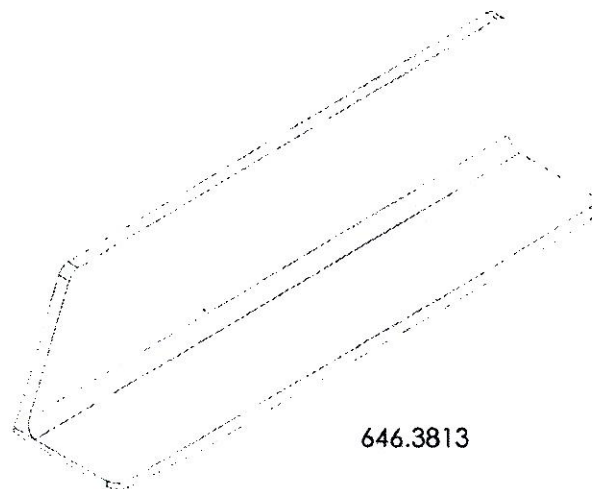
646.3812



NEXT ASSY (S)	ORIGINAL DATE	08-19-08	APICAL INDUSTRIES	
	INFO DATE	08-19-08		
	DRAWN	FORCER	2608 TEMPLE HEIGHTS DR.	
	LOADING		OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWING APPROVAL		BRACKETS	
	CONTRACT NO.		646.3800	
	UNLESS OTHERWISE SPECIFIED		SIT	
	DIMENSIONS ARE IN INCHES		FACE CODE	
	TOLERANCES ARE		8	07M126
	2 PLACE DECIMALS ±.010			
	3 PLACE DECIMALS ±.005			
	ANGLES ±.5°			
			SCALE	NONE
				SHEET 3 OF 3

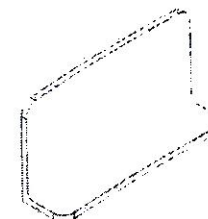
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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

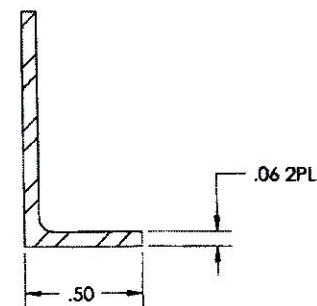
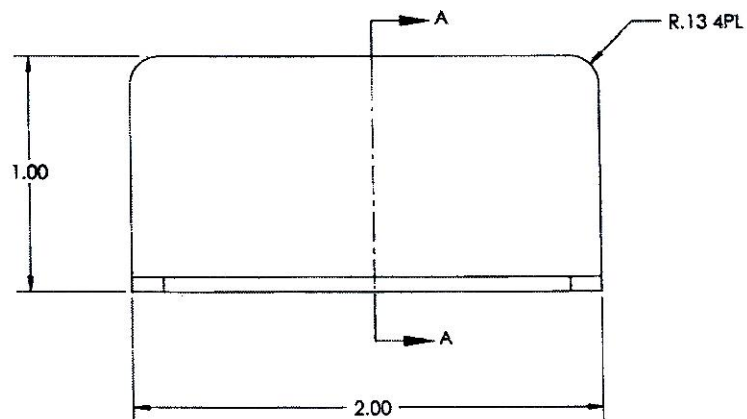


NEXT ASSY (S)	ORIGINAL DATE	06-19-08	APICAL INDUSTRIES	
	UNLESS OTHERWISE SPECIFIED			
	DRAWN BY	J. GARDNER	2608 TEMPLE HEIGHTS DR.	
	DRAWING APPROVAL		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
	CHECKED BY		BRACKETS	
	UNLESS OTHERWISE SPECIFIED		SIZE	1/4" X 1/2"
	TOLERANCES ARE		DWG NO	646.3800
	2 PLACE DECIMALS 1/16"		REV	N/C
	3 PLACE DECIMALS 1/64"		SCALE	NONE
	4 PLACE DECIMALS 1/128"		SHEET	4 OF 5

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



A technical drawing showing a corner of a part with a fillet radius. The fillet is labeled R.06.



SECTION A-A

NEXT ASSY (S)	ORIGINAL DATE DEC-01-89	OR 19-08 CHG#19	APICAL INDUSTRIES 2606 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)/724-5300
	DRAWN BY J. GARDNER	DATE 01-08-90	
	CON. REQ. APPROVA.		
	CONTRACT NO.		BRACKETS
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
	2 BRACKET DIMENSIONS 10.16 3 BRACKET DIMENSION 1.003 4 BRACKET 2		
	SPT. # 07926A	DWG. NO. 646.3800	REV. N/C
	SCALE NONE		SHEET 5 OF 5



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33802**

Purchase Order Date 9/29/2016

PO Print Date 10/12/2016

Page Number 2 of 3

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

3 150933

✓ 646.3813 STRUT REV.
N/N

10/17/2016

5.00

\$6.10

\$30.50

No

10/17/2016

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total:

\$30.50

4 71401-45

ADMIN FEE

10/17/2016

1.00

\$150.00

\$150.00

No

10/17/2016

Line Total:

\$150.00

Note:

10/12/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912400

Date: 17-Oct-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
1 ea	Part: ADMINISTRATION FEE ADMINISTRATION FEE Job: 20266	Rev: N/A Line: PO:	
30 ea	Part: 646.9910 Strut Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20263	Rev: Line: 1 PO: 33802	
10 ea	Part: 647.4212 Plate Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20264	Rev: N/C Line: 2 PO: 33802	
5 ea	Part: 646.3813 Strut Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20265	Rev: N/C Line: 3 PO: 33802	
DATE: 17/10/16			
CERTIFIED SIGNATURE: [Signature]			
RECEIVER SIGNATURE: [Signature] 8/16-10-17			
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
CERTIFICATE OF CONFORMANCE			



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912400

Date: 17-Oct-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
Quantity	Description	
	A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.	
	MADE IN CANADA.	
	SP16-10-17.	